

Split

Work Order ID 91605-2

\*91605\*

Page 1

Item ID: D2065

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Arm

Stop \*NS2\*

Start Date: 10/11/12 Start Qty: 4.00

Required Date: 10/19/12 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2065

Rev C

100

\*100\*

Small Fab

Small Fab

Small Fab

Memo

1-Punch 1/2" OD x .049" Wall 304/316 SS as per Dwg D2065 (per D2727) using DT8012.

Note: 1 end only

2-Cut to length as per Dwg D2065

3-Form as per Dwg D2065 and template DT8251

4-Drill 0.188" Dia holes as per Dwg D2065 using drill jig DT8779 and template

0.00

0.00

SAO 12-11-08

8

FF  
12-11-13

110

\*110\*

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

SPC  
12-12-19

4



Work Order ID 91605

October-17-12 9:54:09 AM

\*91605\*

Page 2

Item ID: D2065 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Arm

Start Date: 10/11/12 Start Qty: 4.00 \*4\* Cust Item ID:  
 Required Date: 10/19/12 Req'd Qty: 4.00 \*4\* Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

\*120\*

Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

M121079

Memo

START TIME: 8:40

OVEN TEMPERATURE: 230

FINISH TIME: 9:14

0.00

\*\*\*\*\*MASK OPEN END OF TUBING\*\*\*\*\*

130

\*130\*

QC

Quality Control

QC3- Inspect Part Finish

0.00

DAS  
15  
2-89

12.12.20

Memo

0.00

140

\*140\*

Packaging

Packaging

Identify as per dwg &amp; Stock Location S1227 0.00

Memo

0.00

4x

SP  
12.12.24





Work Order ID 91605

October-17-12 9:54:09 AM

\*91605\*

Page 3

Item ID: D2065 Accept \*N900040100\* Setup Start \*NS1\*  
Revision ID: Stop \*NS2\*  
Item Name: Arm  
Start Date: 10/11/12 Start Qty: 4.00 \*4\* Cust Item ID:  
Required Date: 10/19/12 Req'd Qty: 4.00 \*4\* Customer:  
Reference:  
Approvals: Process Plan: Date: Tooling: Date: Run Start \*NR1\*  
QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC21- Final Inspection - Work Order Release	0.00							
*150*									
QC	Memo	0.00							
Quality Control									

13/1/10 *[Signature]*  
u 13.01.03



# Picklist Print

October-17-12 1:43:04 PM

Page 1

Work Order ID: 91605

Parent Item: D2065

Parent Item Name: Arm

Start Date: 10/11/12

Required Date: 10/19/12

Start Qty: 4.00

Required Qty: 4.00

Comments: EPP: E02.04.15 Added Dwg Rev.B1NG  
IPP Rev:F 08-07-24 revC as per dwg (ecn 08-504) DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TR0.500W.049  
304 RD Tube .500 x .049W

Purchased

No

f

127.3311

6.8

SAD 12-11-08

Location

Loc Qty

Loc Code

MAT017

127.33111

111814

2.23

115010

109.254058

119087

7.359

120633

8.488052

6.8

6.13.6

6.8

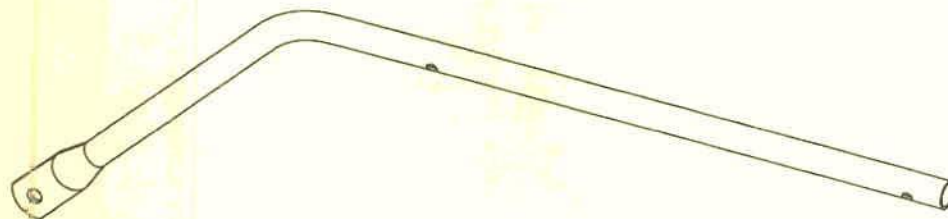
1.7

m/23303









**D2065 ARM**

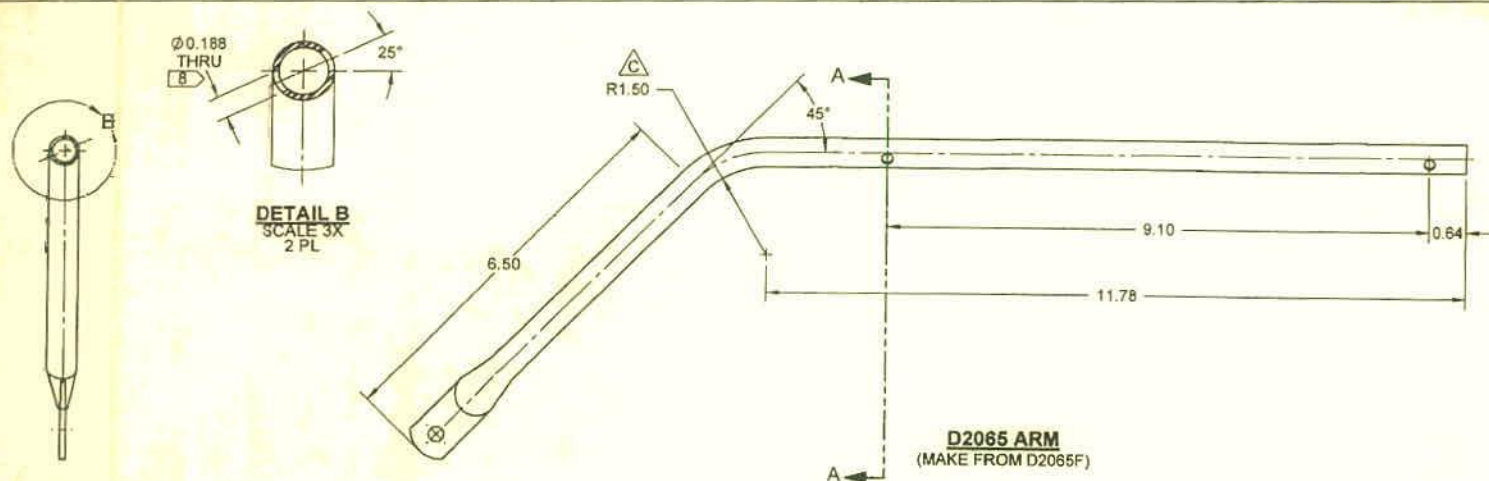
*W/ @ 91605*

**RELEASED**  
*08-07-05.17*

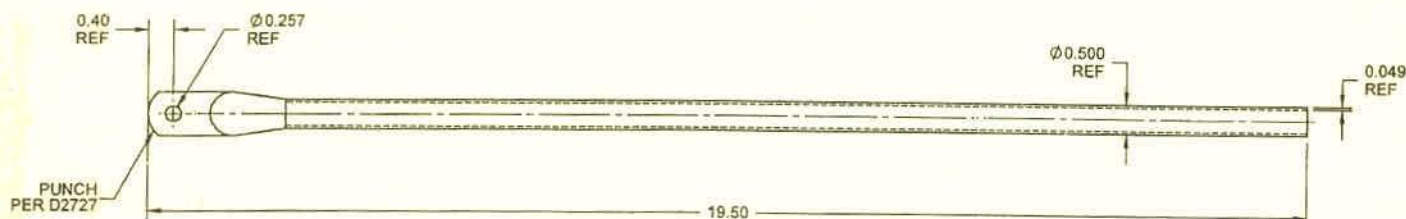
C	REDRAWN IN SOLIDWORKS; INCORPORATED REV. B1 (FINISH ADDED VIA HAND CHANGE) (ZN A5-2); ADD D2065F CUT LENGTH DETAIL FOR D2065 (ZN B3-2); ADD R1.50 DIMENSION (ZN D5-2); Ø 0.500 X 0.049 WALL WAS Ø 0.500 X 0.035 WALL (ZN A5-2); REASON: Ø 0.500 X 0.035 WALL TUBING USED ON D2010 IS CRACKING DURING SERVICE	PH	08.06.13
B	RE-DESIGN	BW	96.02.06
A	NEW ISSUE	BW	92.03.12
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2065	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		ARM	NTS
DATE	08.06.13	COPYRIGHT © 1992 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



8 7 6 5 4 3 2 1





# SECTION A-A



## D2065F ARM CUT LENGTH DETAIL

### NOTES:

- 1) MATERIAL: D2065F: AISI 304/316 SS SEAMLESS ROUND TUBING,  $\phi 0.500 \times 0.049$  WALL (REF DART SPEC M304TR0.500W.049)
- 2) FINISH: POWDER COAT BLACK SANDEK (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.41 lbs
- 8) DRILL:  $\phi 0.188$  AFTER BENDING

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2065	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		ARM	NTS
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08.07.2013

8 7 6 5 4 3 2 1



